



Dart Aerospace Ltd.
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D3078-041
Job Sheet 171764



Part No: D3078-041

Job Qty: 1 ea

Part Name: Step Assembly, Hi Short LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 15.11.12 NEW ISSUE DD VERF:JLM IPP REV:B 16.03.15 DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/22/18	0.00	0.00	Start Up Large Fab-4		DML 18-2-13
110	Large Fab	1 pcs		2/22/18	0.00	1.01	Large Fab 8		DML 18-2-13
120	QC	1 pcs		2/22/18	0.00	0.00	QC6		CPL
130	Large Fab	1 pcs		2/22/18	0.00	1.01	Large Fab 2		CPL
140	QC	1 pcs		2/22/18	0.00	0.00	QC9		PD 18-02-20
150	QC	1 pcs		2/22/18	0.00	0.00	QC5		PD 18-02-20
160	HandFinish	1 pcs		2/22/18	0.00	0.12	HandFinish1		18-02-20 8
170	QC	1 pcs		2/22/18	0.00	0.00	QC7-2		CPL
200	Large Fab	1 pcs		2/22/18	0.00	1.01	Large Fab 2		CPL
210	QC	1 pcs		2/22/18	0.00	0.00	QC10		PD 18-02-22
220	QC	1 pcs		2/22/18	0.00	0.00	QC5		PD 18-02-22
240	HandFinish	1 pcs		2/22/18	0.00	0.12	HandFinish6		18-02-23 8
250	Powdercoat	1 pcs		2/22/18	0.00	0.23	Powdercoat1		BK 18-2-26
260	HandFinish	1 pcs		2/23/18	0.00	0.12	HandFinish3		18-02-26
270	QC	1 pcs		2/23/18	0.00	0.00	QC3		38
290	Packaging	1 pcs		2/23/18	0.00	0.00	Packaging3-1		SMR
300	QC21-SA	1 Ea		2/23/18	0.00	0.00	QC21		21 FEB 28 2018

Part Op 110 - 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

Descriptions: 130 - 1-Bevel end for welding FWD ONLY

200 - 1- Rivet Leg Assembly as per Dwg D3078.

250 - START TIME: 11:00

00:1:30 FINISH 11:30

M138467

wing walk M138761

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	.5000 Ea (.5 ea)	90-Start up Operation	F162484
D3067-1	End Plate	1 Ea (1 ea)	130-Large Fab	5034373
D3219-3	Plate	2 Ea (2 ea)	130-Large Fab	BK1808
D3065-041	Step Leg Assembly	1 Ea (1 ea)	200-Large Fab	5040245
D3066-1	Spacer	2 Ea (2 ea)	200-Large Fab	5036202
D3067-1	End Plate	1 Ea (1 ea)	200-Large Fab	50344373
MS20600-AD4W4	Rivet	16 Ea (16 ea)	200-Large Fab	5034376

59-750

H7x1x112405

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	1	19	0
130-Large Fab	D3067-1	1	84	0
	D3219-3	2	13	0
200-Large Fab	D3065-041	1	22	0
	D3066-1	2	90	0
	D3067-1	1	84	0
	MS20600-AD4W4	16	1,321	0

Part Specifications

Specifications could not be found.

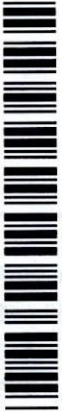
Plex 2/8/18 10:50 AM Dart.lajeunesse.marie

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date : _____		Step # : _____		QTY Effective : _____						MRB (QSI042) Approval	
Description		 Container No: S042217 Part: D3078-041 Serial No/Batch: S042217 Revision: D3078 Inspector: _____ Date: 02/14/18 10:11 AM M.U. 000867  Master Unit 000989 Job No 171764						Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause		DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Crump/kink/ripple/wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Inspection incomplete/unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions incomplete/Unclear ☐ Drill Holes ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐									